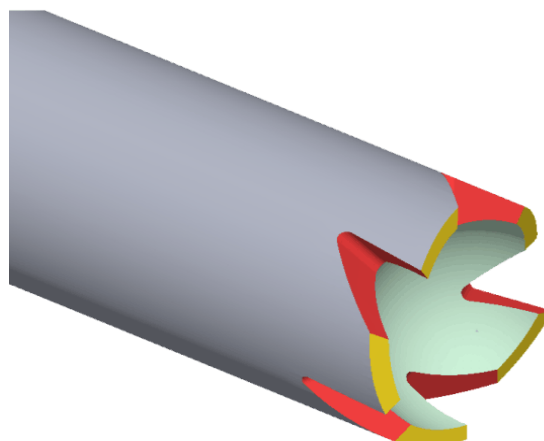







Injection Needle Cutting Tip Ø2.35

A26-400

In order to keep a minimal sharpness of the gashing wheel as well as a good surface finish and avoid burrs, the operations are ground by oscillations. The corindon wheels can be periodically reshaped on a dressing unit.



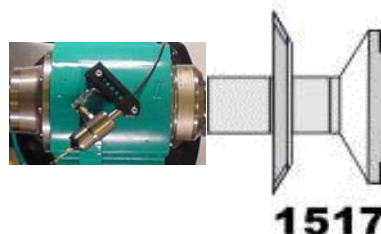
1. Cycletime for Production

Tool specifications			
Diameter 2.35 mm, Z 5, Gash angle 30°			
Material INOX			
Operations			
	Probe	Gashing	End 1
Feed [mm/Min]	2000	500	500
Power [kW]		2	1
Cutting feed [m/s]		32	24
Used wheels			
		15	17
Grinding time [s]	11	49	58
Total cycle time	1 Min 57		

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

15 Ø125 1V1 C500
17 Ø125 12A2 C500



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG, Dressing Unit
Control: Fanuc 31i
Coolant: Synthetic Oil, pressure 6 - 7 bar
Software: Quinto 5

responsible engineer:

www.schneeberger.ch

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